

Linda

Dart Aerospace Ltd.

Date: Thursday, 6/8/2006 1:01:37 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG BRACKET		
Job Number	: 27466			Part Number	: D3046041		
Estimate Number	: 10364			Drawing Number	: D3046 REV. A		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 6/8/2006 S.O. No. : N/A			Drawing Revision	: A		
Prsh Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 6/15/2006 Qty: 6 Um: Each		
Previous Run	: 27188						
Written By	: <u>Say comment Below</u>						
Checked & Approved By	: <u>✓</u>						
Comment	: Est: A 01.08.27 New issue SM/EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :										
1.0	D30461	Lug Bracket										
 Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) LUG BRACKET <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3046-1</td> <td>Lug Bracket</td> <td><u>B 27196</u></td> </tr> </tbody> </table>					Qty	Part Number	Description	Batch	1	D3046-1	Lug Bracket	<u>B 27196</u>
Qty	Part Number	Description	Batch									
1	D3046-1	Lug Bracket	<u>B 27196</u>									
2.0	D30463	Lug Bracket										
 Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) LUG BRACKET Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3046-3 (Bell P/N: 206-052-106-1)</td> <td>Lug Bracket</td> <td><u>N/A</u></td> </tr> </tbody> </table>					Qty	Part Number	Description	Batch	1	D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	<u>N/A</u>
Qty	Part Number	Description	Batch									
1	D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	<u>N/A</u>									
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1										
 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Tranfer drill holes from D3046-3 into D3046-1 as per Dwg D3046 <u>SAAD 06/06/09</u> (6) 2- Counter sink inside holes of D3046-1 as per Dwg D3046 3- Deburr 												
4.0	MS20426AD57	Rivet										
 Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s) Rivet <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>10</td> <td>MS20426AD5-7</td> <td>Rivet</td> <td><u>M 387C</u></td> </tr> </tbody> </table>					Qty	Part Number	Description	Batch	10	MS20426AD5-7	Rivet	<u>M 387C</u>
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10	MS20426AD5-7	Rivet	<u>M 387C</u>									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/09
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/8/2006 1:01:37 PM
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Drawing Name: LUG BRACKET

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Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB

06/06/09

6

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DC 06/06/09

6

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/06/09 (6) SB 06/06/09

6

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

SB 06/06/09

6

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/09

6

Job Completion



N 06/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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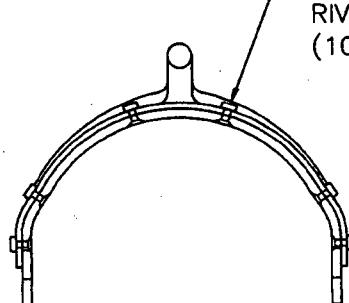
DART

DESIGN		DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED		DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
			D3046	REV. A
DATE				SHEET 1 OF 2
01.08.23			TITLE	SCALE
			LUG BRACKET	1:2
A	01.08.23		NEW ISSUE	

UNDER REVIEW

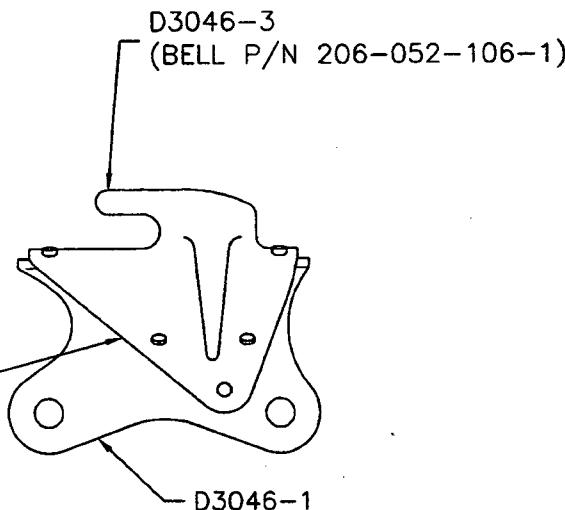
06.06.02 RP

CHANGES TO BE INCLUDED

RELEASED
(a.08-27)

TRANSFER DRILL \varnothing 0.156 HOLES
FROM D3046-3 TO D3046-1.
C'SINK \varnothing 0.286 x 100°
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)

CENTER D3046-3
ON D3046-1

**D3046-041 LUG BRACKET ASSEMBLY****NOTES:**

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

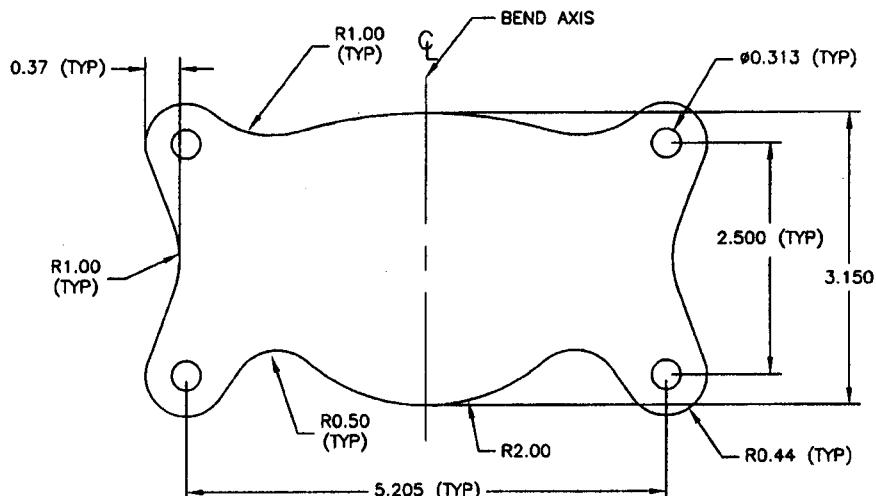
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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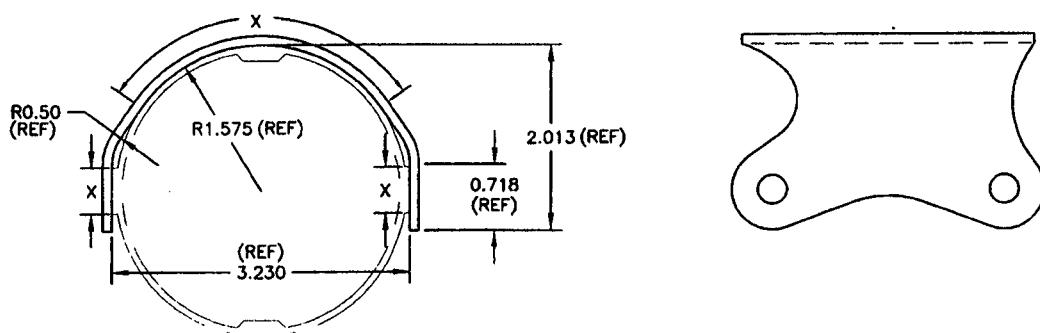
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3046
DATE	01.08.23	REV. A SHEET 2 OF 2 TITLE LUG BRACKET SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

UNDER REVIEW

08.08.23

RELEASED
01.08.23

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